Monday, 8/21/2006 2:13:34 PM Date: Kim Johnston User: **Process Sheet** : PLATE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 28271 **Estimate Number** : 10425 : NIA : D32191 Part Number P.O. Number : D3219 REV A S.O. No. : N/A **Drawing Number** This Issue : 8/21/2006 Project Number : N/A : NC Prsht Rev. : NIA : MACHINED PARTS **Drawing Revision** Type First Issue : NIA : 28027 Material **Previous Run** Each : 9/5/2006 40 Um: Qty: **Due Date** Written By Checked & Approved By New issue KJ/JLM : Est. A04.04. Comment ESR B 06.05.25 Waterjet **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 1.0 M6061T6S125 6061-T6 .125 Sheet 0.1012 sf(s)/Unit Total: 4.0488 sf(s) Comment: Qty.: 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: <u>M101692</u> 4L FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev:_ Prog Rev:_ <u>06:08:11</u> 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 42 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 06:08:24 SECOND CHECK 4.0 QC8 Comment: SECOND CHECK

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W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
06-06-28	2	debur At Step S. Perm. Change					05.08:08		

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Annroyal	Approval		
STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category:	NCR:	Yes 😡	DQA:	Date: <u>06/09/06</u>
NOTE: Date & initial all entries				QA: N/C C	losed:	Date:

Date: Monday, 8/21/2006 2:13:34 PM User: Kim Johnston **Process Sheet** Drawing Name: PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 28271 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 (42 1-Deburr if necessary. 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stoc Location 8.0 Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



CZ06/09/05

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			ORK ORDER CHANGES						
STEP	PRO	OCEDURE CHA	NGE	Ву	By Date		Qty Approval Mfg / Design Mgr	Approval QC Inspector	
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		WORK ORD	ER NON-CONFORMANO	CE (NCI	₹)				
OTED	Description of NC		Corrective Action Section B		Verif	ication	Approval	Approval	
SIEP	Section A	Initial Design Mgr	Action Description Design Mgr		Sign & Section C Do	Design Mgr	Mgr QC Inspector		
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Design Mgr	STEP Description of NC Section A Initial Design Mgr Design Mgr Corrective Action Section B Action Description Design Mgr	STEP Description of NC Section A Initial Design Mgr Design Mgr Corrective Action Section B Initial Design Mgr Design Mgr Design Mgr Design Mgr	STEP Section A Initial Action Description Sign & Design Mgr Design Mgr Sec	STEP Description of NC Section A Initial Design Mgr Design Mgr Design Mgr Design Mgr Design Mgr Design Mgr Date Corrective Action Section B Initial Design Mgr Design Mgr Date Verification Section C	STEP Description of NC Section A Initial Design Mgr Des	

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	
NOTE: Date & initial all entries				QA: N	N/C C	losed:	Date:	

DART AEROSPACE LTD	Work Order:	28271
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Arti	cle	Prot	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	C	omments	S
Ø0.316	+0.005/-0.000	00.317			Vern			
2.293	+/-0.005	2.292			Vern			
2.965	+/-0.010	2.965	1		Vern			
0.566	+/-0.010	\$60.561	~		Vern			
0.375	+/-0.010	0.370	/		Vern			
R0.125	+/-0.010	RO.125	/		R-6			
0.125	+/-0.010	0.122	1		Vern		. 4	
13.9	+/-0.010	13.9	W/FI)		CAN	T Do	<u>it</u>
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Measured by:	SAO	Audited by:	1	Prototype Approval:	N/A
Date:	06:08:24	Date:	06-06-29	Date:	N/A

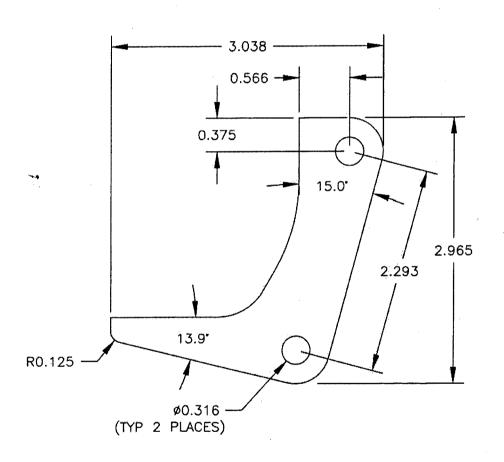
Rev	Date	Change	Revised by	Approv ∉ d
Α	04.04.19	New Issue	KJ/JLM A	
	<u> </u>			





	DESIG	a	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
	CHECK	ED	APPROVED	DRAWING NO. D3219 SF	REV. A
***************************************	DATE			TITLE	SCALE
į	03.1	0.10		PLATE	1:1
	Α		03.10.10	NEW ISSUE	





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015 4)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

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